

Work Order ID 81457-1

Wednesday, March 14, 2012 11:01:25 AM

81457

Page 1

Item ID: D3912-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Eyebolt Receiver Assembly 3
 Start Date: 3/14/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 3/30/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: MF Date: 12-03-14 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3912	B

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1-Assemble D3912-1/-3/-5 and install rivets as per dwg TRIM RIVETS 1.250" LONG								
	2- Install helical, spring plunger and spring pin lanyard assy as per dwg								

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

3x ϕ 12/04/27

3x ϕ 12/04/27
 110 \rightarrow

5.2/14/27

(43)

W/O: 81457-1

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3912-041 PAR #: _____ Fault Category: Machining NCR: (Yes) No DQA: AK Date: 12/05/04
 Resolution: * Scrap Disposition: Scrap QA: N/C Closed: LF Date: 12/5/7

NCR: 12-1357

WORK ORDER NON-CONFORMANCE (NCR) 222.75

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/04	110	found 1 D 3912-1 from Store that is incorrect R.L. Machining / operators	<u>S</u> 12/04/07 057042	Scrap & destroy No replace	<u>SP</u> 12/01/16	<u>S</u> 12/01/27	<u>S</u> 057042	<u>S</u> 12/04/07

NOTE: Date & initial all entries

Work Order ID 81457

81457

Page 2

Wednesday, March 14, 2012 11:01:25 AM

Item ID: D3912-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eyebolt Receiver Assembly
 Start Date: 3/14/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/30/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>57B11</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

4/14/12 (3)

12/4/30

h12.04.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 14, 2012 11:01:24 AM

Page 1

Work Order ID: 81457

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B 10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R Washer		Purchased	No				Each	196.0000		6			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST297		196							
				116893		196							
D3912-1 Eyebolt		Manufactured	No			100	Each	22.0000	1	6			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG091		-12							
				69593		0							
				ST070		21							
				77073		12							
				77552		9							
				ST091		13							
				69593		1							
D3912-3 Eyebolt Block		Manufactured	No			100	Each	10.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST070		10							
				77554		10							
D3912-5 Eyebolt Plate		Manufactured	No			100	Each	7.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST070		7							
				76961		7							

GPB 12/04/27

3

GPB 12/04/27

GPB 12/04/27

B82040 (6x)

GPB 12/04/27

B82042 (6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 14, 2012 11:01:25 AM

Page 2

Work Order ID: 81457

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

D3801-1 Manufactured No

Each 18.0000

6

Hand Retractable Spring Plunger

Location	Loc Qty	Loc Code
GA	6	
80996	6	
ST064	12	
68379	2	
75178	10	

MS20615-4M20 Purchased No

100 Each 122.0000

8

48

RIVET

Location	Loc Qty	Loc Code
FP	50	
120644	50	
GA	72	
119546	26	
119638	46	

MS21209-F615 Purchased No

Each 64.0000

6

Heli-Coil

Location	Loc Qty	Loc Code
ST304	18	
108170	11	
108244	7	
ST305	46	
108170	0	
108244	0	
120072	46	

EP 3/12/04/16
B81810 (3x)
EP 3/12/04/16
25
M121339 (23x)
EP 3/12/04/16
M121561 (3x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

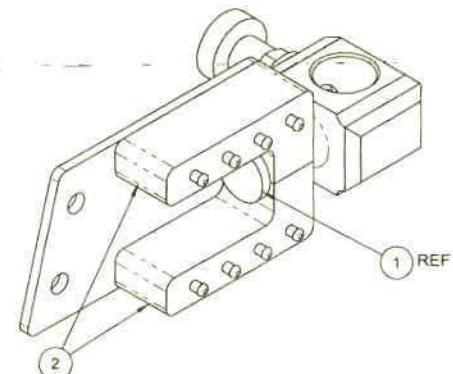
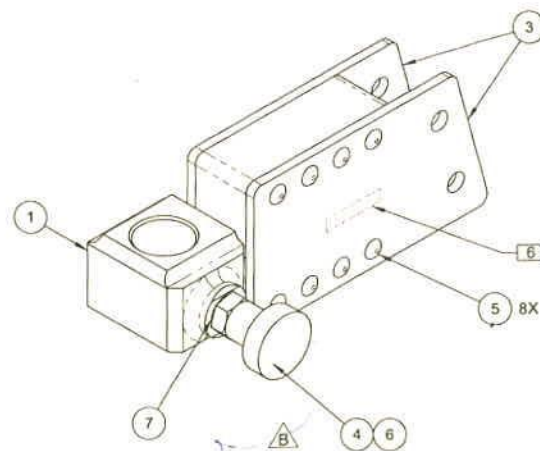
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20815-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

81457

RELEASED
2010-07-16

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0603R ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ASS		
DRAWN	ASS		
CHECKED	ASS		
MFG. APPR.	ASS		
APPROVED	ASS		
DE APPR.	ASS		
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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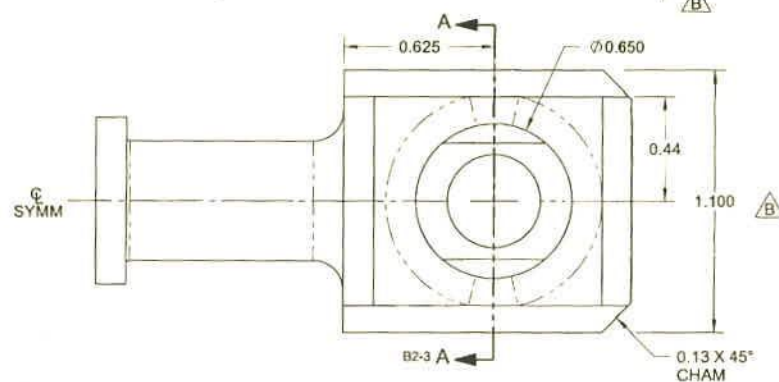
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3912	SHEET 2 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	EYEBOLT RECEIVER ASSY	
DATE	10.06.28	NTS	

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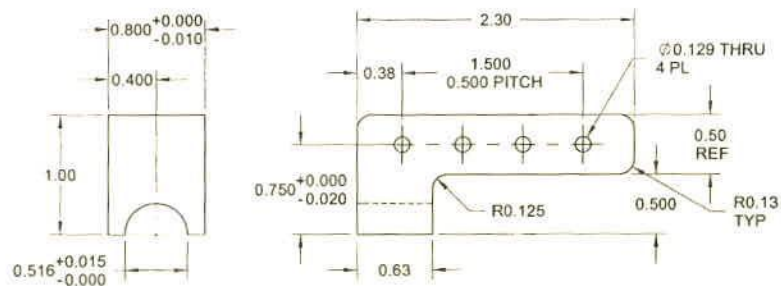
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

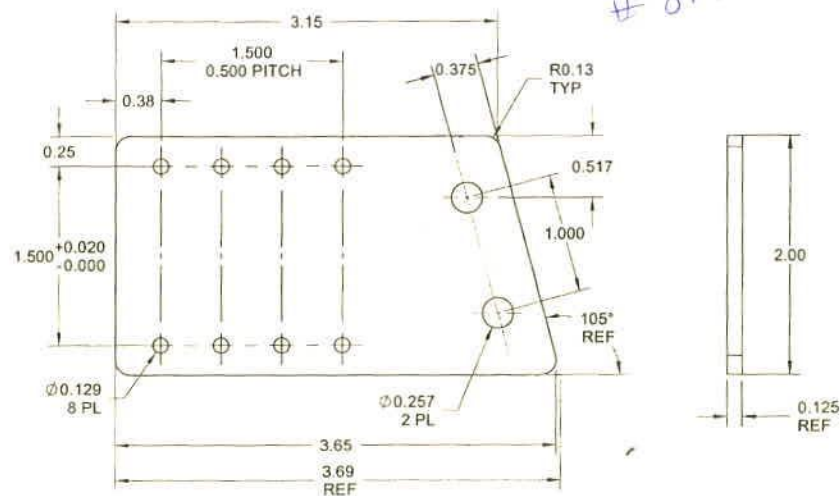
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
JD

DESIGN	<i>AJS</i>	DART AEROSPACE LTD	
DRAWN	<i>AJS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AJS</i>	D3912	SHEET 3 OF 3
APPROVED	<i>AJS</i>	TITLE	SCALE
DE APPR.	<i>AJS</i>	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81496

March-14-12 4:23:30 PM

81496

Page 1

Item ID: D3212-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Window
 Start Date: 14/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 28/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/14 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3212	C

100 0.00

100 FLOW WATER JET

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut blankas per Dwg D3212 Dwg Rev: C Prog Rev: C

2-Deburr if necessary

110 0.00

110 HAAS CNC VERTICAL MACHINING #1

HAAS 1 Memo 0.00

HAAS CNC vertical machine #1 Machine as per Folio FA349 and Dwg D3212

120 0.00

120 QC2- Inspect parts off machine FAI/FAIB

QC Memo 0.00

Quality Control

B12-3-24

(10)

SL 12/04/05

(8)

B12-3-24

(P10) →

SL 12/04/05

8

p

W/O: 81496		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3212-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: Yes Date: 12/05/04
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 12/5/7

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-1390 12/04/05	110	1st part on top of stack broke in one corner during center drilling R.C. Press / tooling	S ASZ042 12/04/05	Scrap + Destroy no Replie	OK 12/04/05	S 12/04/05	S ASZ042 12/04/05	S 12/04/05
12/04/05 12-1391	110	1 part the hole are oval .170" X .160" R.C. operate error / tool	S ASZ042	Scrap + Destroy no Replie	OK 12/04/05	SL 12/04/05	S 12/04/05 ASZ042	S 12/04/05

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries